

Work Order ID 56235

Wednesday, February 17, 2010 10:06:40 AM



Page 1

Item ID: D412-769-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Facing Seat, RH

Start Date: 2/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 3/3/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *u*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-769

Rev B

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D412-769-042 CHG 001

0.00

0.00

100.1

Pick Kit →

5/10/12

10-3-24 SP

HJ for BG 10/03/08

110



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

5/10/12

H
RH

120



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-769-042 Location: _____ PPP Rev: _____

0.00

0.00

Pa 10/13/12

PPN 56231

(P10)

W/O: 56235

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
|----------|----------------------|----------------------------|--------------------|----------|-----|-------------------------------------|--------------------------------|
| 10-03-22 | W/O Dwg Leader | IIN now 2 Rev. C. / update | <i>[Signature]</i> | 10.03.23 | | <i>[Signature]</i> 10/03/22 | <i>[Signature]</i> 10/03/22 |
| | | | | | | | |

Part No: D412-769-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID⁵ 56235

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Page 2

Item ID: D412-769-042

Revision ID:

Item Name: Aft Facing Seat, RH

Start Date: 2/18/2010 Start Qty: 1.00

Required Date: 3/3/2010 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24 *[Signature]*

MF

10-3-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 17, 2010 10:06:40 AM

Page 1
1

Work Order ID: 56235



Parent Item: D412-769-042



Parent Item Name: Aft Facing Seat, RH

Comments: IPP rev A 08-07-17 new issue DD verified by:EC

Start Date: 2/18/2010

Required Date: 3/3/2010

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| 5 D412-724-041 | | Manufactured | No | | | 110 | Each | 0.0000 | 1.0000 | | | |
| Head Rest Assembly, Center | | | | | | 10-35 | | | | | | |
| 6 D412-724-044 | | Manufactured | No | | | 110 | Each | 0.0000 | 1.0000 | | | |
| Head Rest Assembly, RH | | | | | | | | | | | | |
| 5 D412-769-044 | | Manufactured | No | | | 110 | Each | 0.0000 | 1.0000 | | | |
| Aft Facing Seat Assembly, RH | | | | | | | | | | | | |

B 56241 SP

B 56326 SP

B 56239 / 10/3/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|---------------------------------------|---------|----------|--------------|--------------|------------|
| | | Arm | Moment | Arm | Moment |
| D412-769-011 | 60.0 lb | 0.0 in | 0.00 in-lb | 87.0 in | 5220 in-lb |
| Aft Facing Seat kit | 27.2 kg | 0.0 m | 0.00 m-kg | 2.21 m | 60.11 m-kg |
| D412-769-041 | 30.0 lb | -16.1 in | -483.0 in-lb | 87.0 in | 2610 in-lb |
| Aft Facing Seat, LH (normal position) | 13.6 kg | -0.41 m | -5.58 m-kg | 2.21 m | 30.06 m-kg |
| D412-769-042 | 30.0 lb | +16.1 in | +483.0 in-lb | 87.0 in | 2610 in-lb |
| Aft Facing Seat, RH (normal position) | 13.6 kg | +0.41 m | +5.58 m-kg | 2.21 m | 30.06 m-kg |
| D412-769-041 | 30.0 lb | -1.1 in | -33.0 in-lb | 87.0 in | 2610 in-lb |
| Aft Facing Seat, LH (center position) | 13.6 kg | -0.03 m | -0.41 m-kg | 2.21 m | 30.06 m-kg |
| D412-769-042 | 30.0 lb | +1.1 in | +33.0 in-lb | 87.0 in | 2610 in-lb |
| Aft Facing Seat, RH (center position) | 13.6 kg | +0.03 m | +0.41 m-kg | 2.21 m | 30.06 m-kg |
| D412-769-041 | 30.0 lb | +13.9 in | +417.0 in-lb | 87.0 in | 2610 in-lb |
| Aft Facing Seat, LH (right Position) | 13.6 kg | +0.35 m | +4.76 m-kg | 2.21 m | 30.06 m-kg |
| D412-769-042 | 30.0 lb | -13.9 in | -417.0 in-lb | 87.0 in | 2610 in-lb |
| Aft Facing Seat, RH (left Position) | 13.6 kg | -0.35 m | -4.76 m-kg | 2.21 m | 30.06 m-kg |

5. PARTS LIST

| Qty -011 | Qty -041 | Qty -042 | Part Number | Description |
|----------|----------|----------|--------------|------------------------------|
| X | | | D412-769-011 | AFT FACING SEAT KIT |
| 1 | X | | D412-769-041 | AFT FACING SEAT, LH |
| 1 | | X | D412-769-042 | AFT FACING SEAT, RH |
| 1 | | | D412-769-043 | AFT FACING SEAT ASSEMBLY, LH |
| 1 | | 1 | D412-769-044 | AFT FACING SEAT ASSEMBLY, RH |
| 1 | | 1 | D412-724-041 | HEAD REST ASSEMBLY, CENTER |
| 1 | | 1 | D412-724-043 | HEAD REST ASSEMBLY, LH |
| 1 | | 1 | D412-724-044 | HEAD REST ASSEMBLY, RH |

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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NOTE: Date & initial all entries